

Work Order ID 100609-1

Wednesday, April 24, 2013 11:52:36 AM

100609

Page 1

Item ID: D3969-1

Revision ID:

Item Name: Spring (Basket Lid)

Start Date: 4/24/2013 Start Qty: 20.00

Required Date: 4/26/2013 Req'd Qty: 20.00

Reference:

Accept

N900040100

Setup

Start

NS1

Stop

NS2

16 *20*
20

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3969	C
-------	---

100

100

Purchasing

Memo

Issue P/O: PAF3

Order as per Dwg D3969

Possible supplier: LS Technologies

part#: SSA4/6-122-315-310N

Material release note is required

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

PL 13-04-24

16X

SL 13-6-6

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS							
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other						
Part No. _____ NCR No. _____													
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

Work Order ID 100609

Wednesday, April 24, 2013 11:52:36 AM

100609

Page 2

Item ID: D3969-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spring (Basket Lid)

Start Date: 4/24/2013 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/26/2013 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

S

0.00

B-6-6

16

120

QC

Quality Control

130

Identify as per dwg & Stock Location: 85262 0.00

0.00

16x

B-6-7

130

Packaging

Packaging

Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00

13/6/10 JJ

MB

B-6-10

140

QC

Quality Control

Memo

0.00

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend		Grain		Ovalized		Pressure/Forced		Temperature/Cure	
Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Weld		Wrong Stock Pulled	
Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect					
Crushed/Crimped		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing					
Cuffs		Contamination		Maintenance		Part Moved					
Heat Treat		Countersink		Mislabeled		Positioned Wrong					
Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge		Other			
Ripples in Bend		Drill Holes		Offset							
Torque Waves in Extrusion		Drawing		Out of Calibration							
Turning Sequence		Finish		Out of Sequence							
Wave/Twist in Tube		Folio		Outside Dimensions							

Picklist Print

Wednesday, April 24, 2013 11:54:26 AM

Page 1

Work Order ID: 100609

Parent Item: D3969-1

Parent Item Name: Spring (Basket Lid)

100609

D3969-1

Start Date: 4/24/2013

Start Qty: 20.00

Required Date: 4/26/2013

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC
as per revC DD 10.03.16 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

SSA4/6-122-315-310N

Purchased

No

110

Each

0.0000

**

20

SSA4/6-122-315-310N

Gas Spring

16x SP 13-Lo-6

NCR: Yes / No

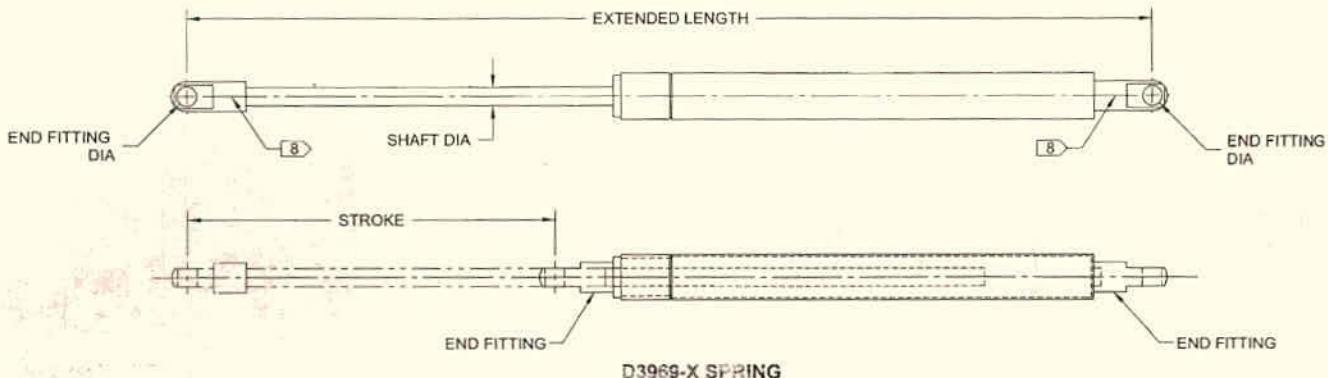
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
Part No. _____			Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
NCR No. _____			Work Order Update <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>			
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General							
				<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced				
				<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure				
				<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld				
				<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled				
				<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved					
				<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong					
				<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge					
				<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Other					
				<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration						
				<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence						
				<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions						

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	120/4.70	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	120/4.70	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	120/4.70	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs

RELEASED
R 2010-03-12
MP

C	REDRAWN IN SW, ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART, FORCE FOR -1 CORRECTED (WAS 60.0 lbs.)			JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID)			AJS	09.11.10
A	NOTE 8 ADDED.			AJS	09.07.27
REV.	NEW ISSUE				BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS	DRAWING NO. D3969			
CHECKED	<i>RP</i>	REV. C			
MFG. APPR.	N/A	SHEET 1 OF 1			
APPROVED	<i>AS</i>	TITLE			
DE APPR.	<i>AS</i>	SCALE NTS			
DATE	10.03.04	BASKET LID SPRING			
COPYRIGHT © 2009 BY DART AEROSPACE LTD. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR OTHERWISE DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.					

NOTES:

- 1) MATERIAL: SEE CHART
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE CHART
- 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

LS TECHNOLOGIES INC

314 Jessop Ave
Saskatoon , SK S7N 1Y6

Ph # (306) 683-5000

Packing Slip

P.O. No.	Date	Invoice #
19683	6/04/2013	9931

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
5/09/2013		

Qty	Description
✓ 16	D3969-1 B100609 Stainless Gas Spring (SSA4/6-122-315-310N)
✓ 26	D3969-3 B100611 Stainless Gas Spring (SSA4/8-122-310-360N) Shipping Via FED EX Tracking # 799917013781 <i>SP 13-6-6</i>



LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance
June 4, 2013

This is to certify that the parts listed below meets specifications as required by your order.

16 Units: D3969-1 B100609 Stainless Gas Spring (SSA4/6-122-315-310N)

26 Units : D3969-3 B100611 Stainless Gas Spring (SSA4/8-122-310-360N)

Country of Manufacture: Canada
Date of Manufacture : May 2013
This product is ROHS compliant.

Purchase Order # PO19683
Invoice # 9931

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr". It is written in a cursive style with a horizontal line underneath it.

Nolan Fehr
Manager



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19683

Purchase Order Date 4/24/2013

PO Print Date 4/24/2013

Page Number 1 of 1

Order From : VC-LST0001

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

Contact Name	Buyer	Brigitte Golden
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
Vendor Part Number							
1	SSA4/6-122-315-310N	Gas Spring	4/26/2013 Yes	20.00 Each	FedEx PI collect <i>Meccy</i>	\$65.0000	\$1,300.00
Special Inst: AS PER DWG: 3969 REV: C B100609							
2	SSA4/8-122-310-360N	Gas Spring	4/26/2013 Yes	50.00 Each	FedEx PI collect <i>Meccy</i>	\$65.0000	\$3,250.00
Special Inst: SAME AS ABOVE B100611 <i>SP 13 - 66</i>							
PO Total:							\$4,550.00

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required - YES NO

Change Nbr: 1

Change Date: 4/24/2013